

SPLIT

Date: Friday, 04/04/2008 9:58:52 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 38408 *✓*
 Estimate Number : 12784
 P.O. Number :
 This Issue : 04/04/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 04/04/2008 Type : SMALL /MED FAB
 Previous Run : 37812
 Written By :
 Checked & Approved By : *JDL 08-04-08*
 Comment : Est Rev:A New Issue 07-03-08 ec
 Est Rev:B As per Rev C 07-07-09 JLM
 Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC

(19)

Drawing Name : WEARPAD
 Part Number : D35649
 Drawing Number : D3564 REV D
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 18/04/2008
 Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet 33 33
		Comment: Qty.: 1.1550 sf(s)/Unit Total: 23.1000 sf(s) $107513 \times 6 = 1$ M304S16GA Stainless steel sheet 0.063" thick $107676 \times 22 = 2$ Batch:
2.0	WATER JET	FLOW WATER JET 28
		Comment: FLOW WATER JET 1-Cut as per Dwg D3564 ****(D3564-1F)**** Dwg Rev: <i>D</i> <i>HB 8-4-10</i> Prog Rev: <i>D</i>
		2-Deburr if necessary <i>HB 8-4-10</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>HB 8-4-10</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK <i>HB 8-4-10</i> <i>28</i> <i>Count</i>
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE <i>HB 8-4-10</i> <i>28</i>
		Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT <i>8179</i> and DT <i>8155</i>

*88 08/04/17**28*

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Part Number: D35649

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form Joggle as per Dwg D3564 on brake using Jig DT 8157

SB 08/04/17 (28)

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

08/04/17 (28)

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty	Description	Batch
A/R	2059B Hardcoat	M107051
Weld hardcoat as per Dwg D3564		M107115

28x 19

08-04-21

SP

8.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

5 08/04/22 (15)

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/04/22 (15)

30 min
23/04/2008

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

S.097 11.36

#1 317.1 F

#2 38408- F

#3 0.35649 F

11.0 QC3

INSPECT POWDER COAT/ CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/ CHEMICAL CONVERSION

m-1 08/04/23

4x

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-18

m-1 08/04/23

19x

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Job Number: 38408

Part Number: D35649

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/2008

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-23



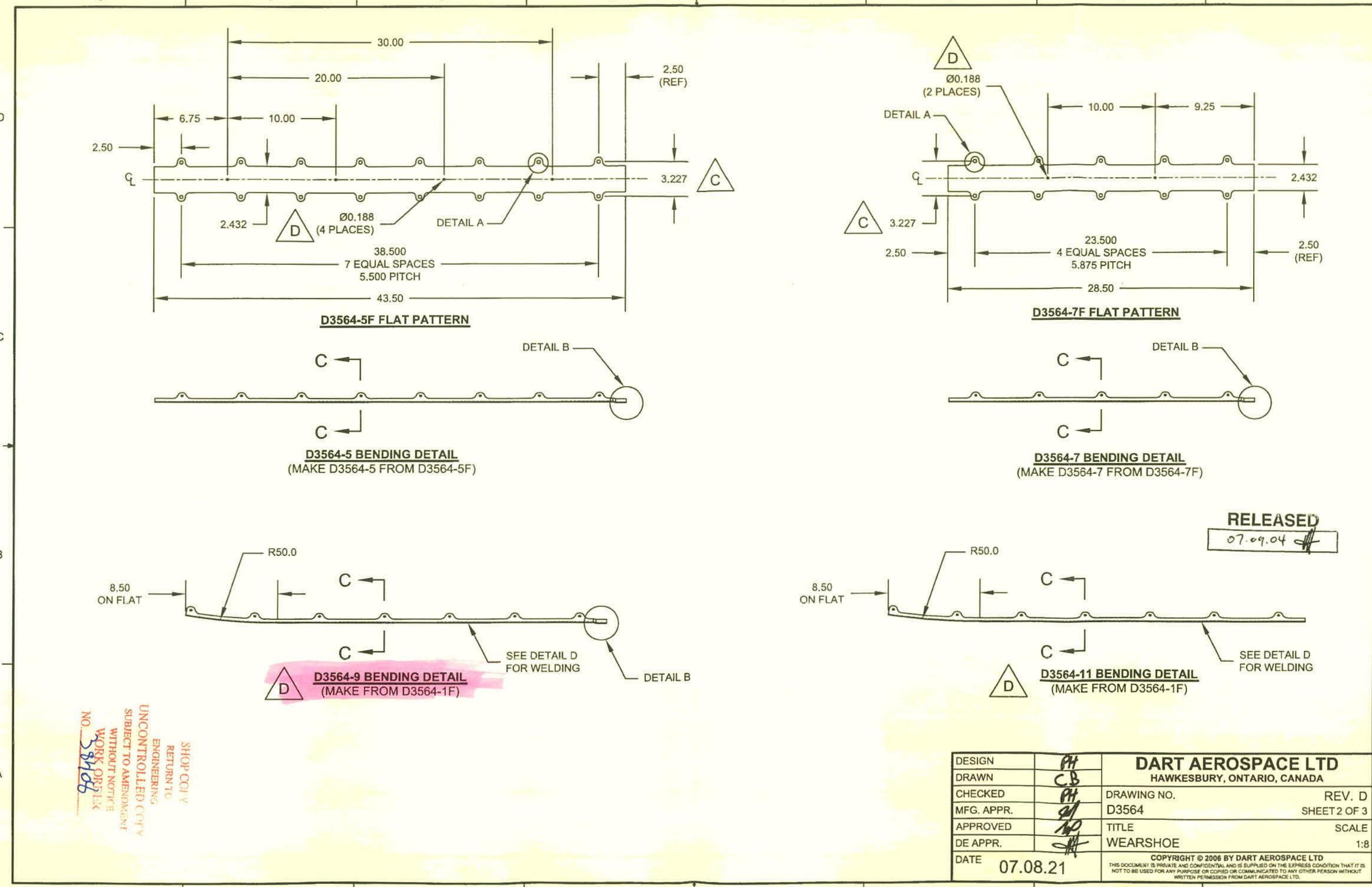
DART AEROSPACE LTD	Work Order:	3840R
Description: Wearshoe	Part Number:	D3564-9
Inspection Dwg: D3564	Rev: D	Page 1 of 1

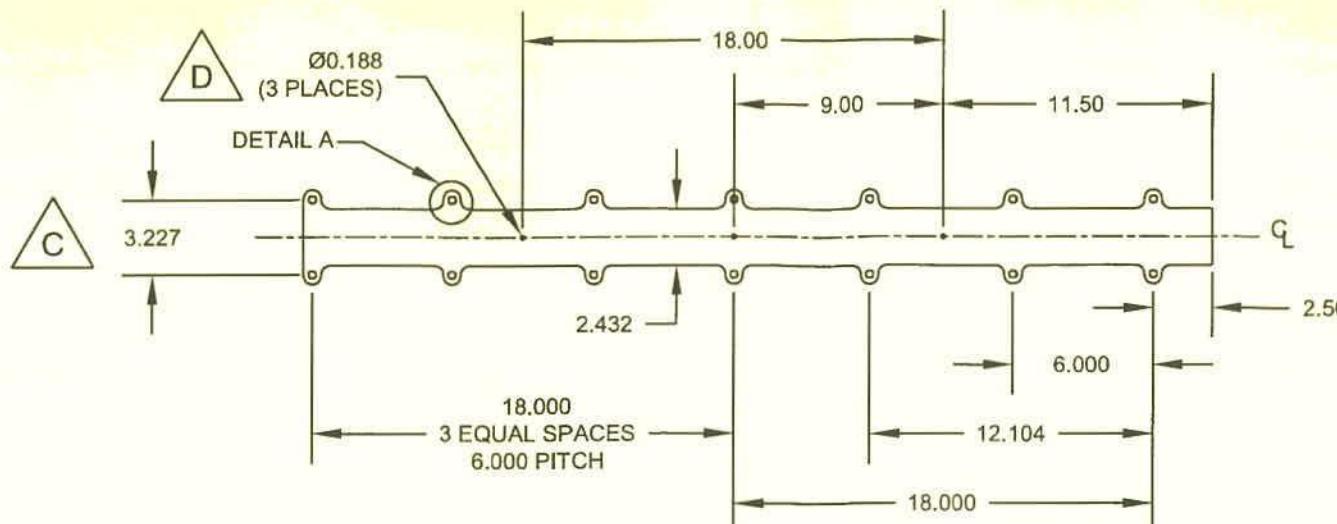
FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by: <u>BS</u>	Audited by: <u> </u>	Prototype Approval: N/A
Date: <u>BS 8-4-10</u>	Date: <u>09/04/10</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	

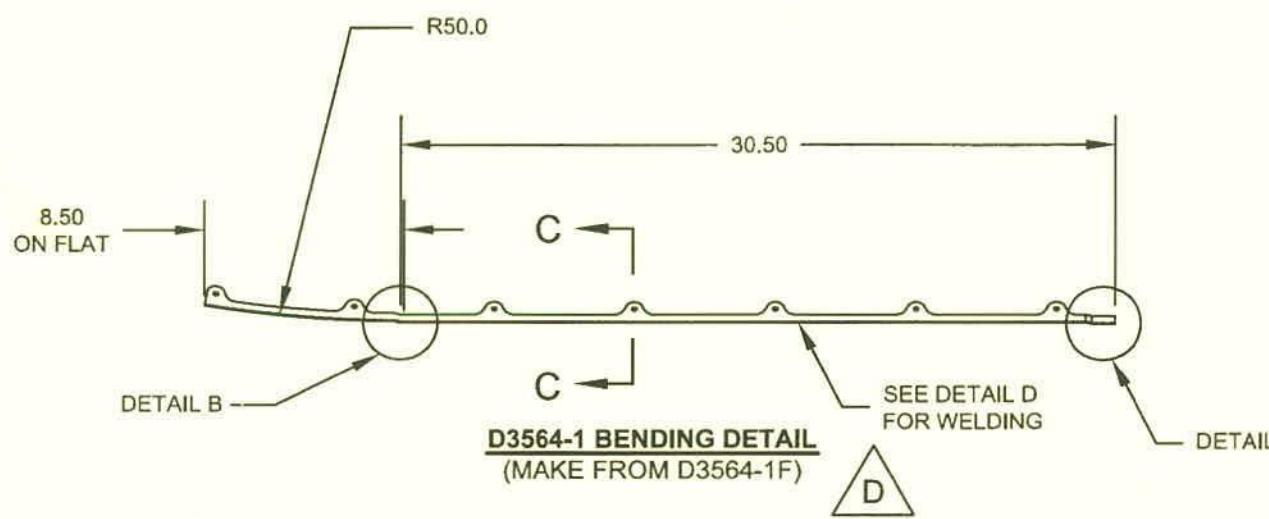




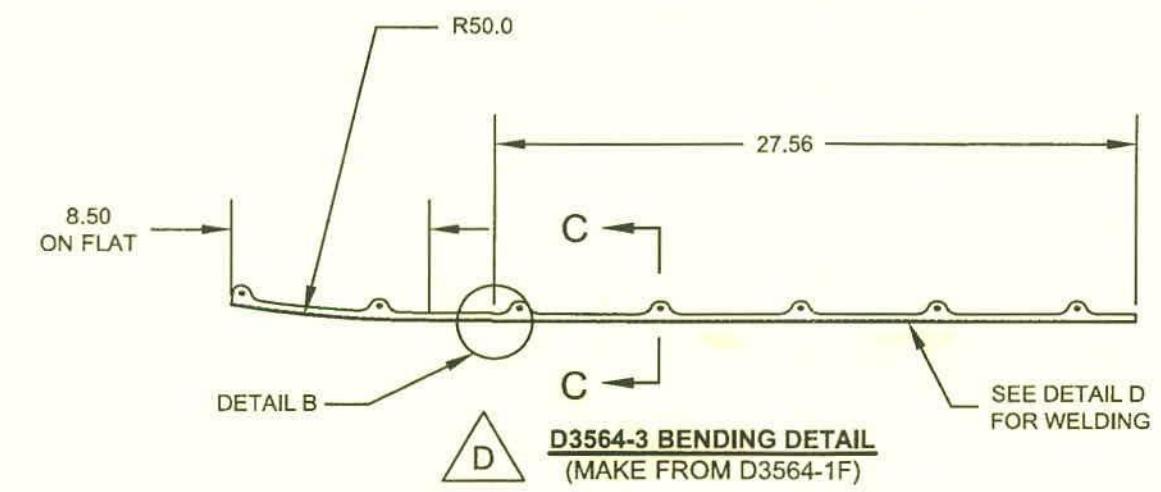
D3564-1F FLAT PATTERN

RELEASED

07.09.04 ~~✓~~



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

RETURN TO
STOKE
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38409

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTE

D5904-17-5/-5/-7/-5/-11/-15/-19 WEAR PLATE NOTES:

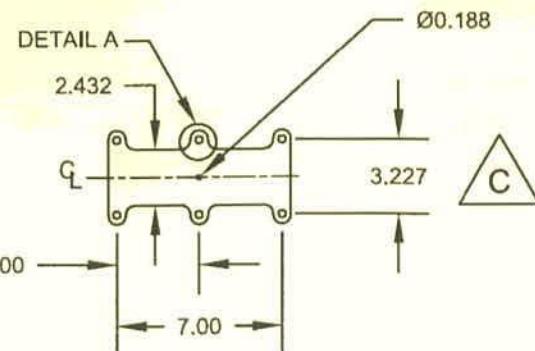
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICKNESS)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT \odot

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

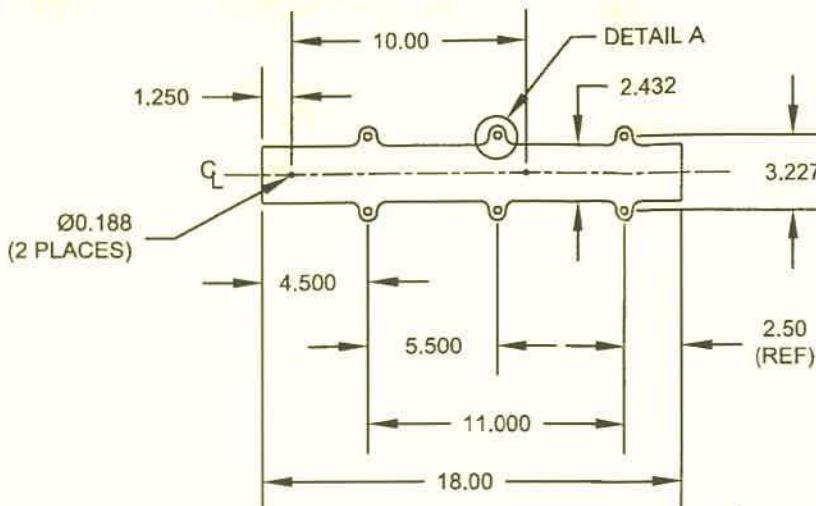
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	SI	D3564	SHEET 1 OF 3
APPROVED	10	TITLE	SCALE
DE APPR.	SI	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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8 7 6 5 4 3 2 1



D3564-13F FLAT PATTERN



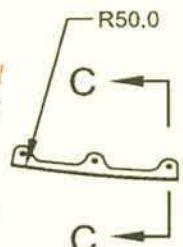
D3564-15F FLAT PATTERN

2059B HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH
(11 PLACES)
WELD AFTER BENDING AS ILLUSTRATED PER DT8308

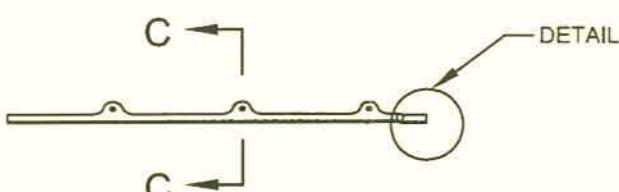


DETAIL D
(D3564-1/3-9-11 WELDING DETAIL)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38406

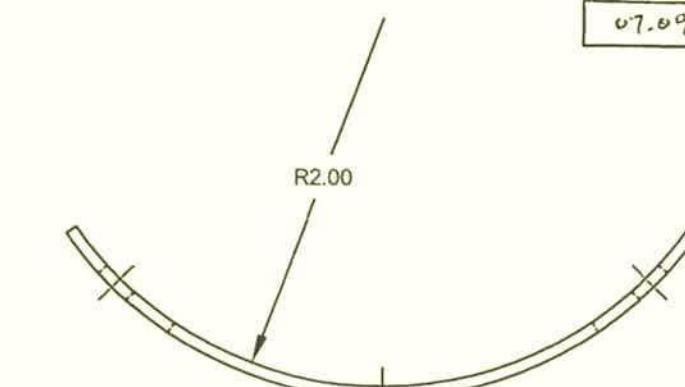


D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)

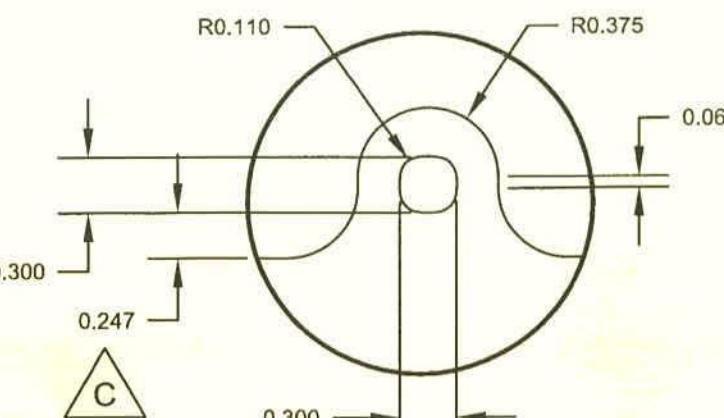


D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

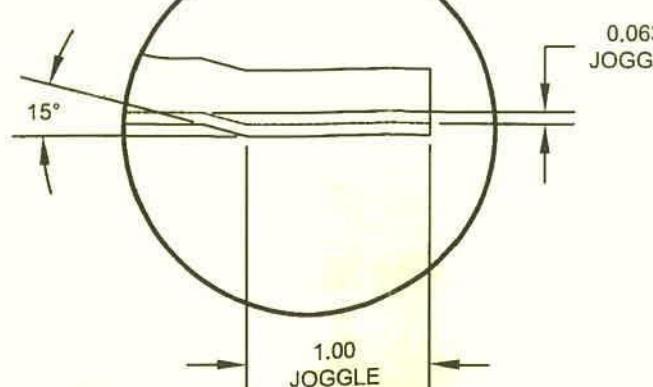
RELEASED
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	<i>PH</i>	DART AEROSPACE LTD
DRAWN	<i>CB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	DRAWING NO.
MFG. APPR.	<i>PH</i>	D3564
APPROVED	<i>PH</i>	REV. D
DE APPR.	<i>PH</i>	SHEET 3 OF 3
DATE	07.08.21	TITLE
		WEARSHOE
		SCALE
		1:8

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